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2053

C3-8-2
Job Sheet 184032



Part No: C3-8-2

Job Qty: 10 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-8-2 Rev 3 IPP Rev A 18.04.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off	DAS
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time		
90	Start up Operation	10 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Small Fab-4			30
100	Small Fab	10 pcs	10/5/18	10/5/18	0.00	0.50	Small Fab-9		M.L. DAS	9-89
110	QC	10 pcs	10/5/18	10/5/18	0.00	0.00	QC5			30
130	Packaging	10 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-2		DAS	9-89
140	QC21-FG	10 Ea	10/5/18	10/5/18	0.00	0.00	QC21		21	DEC 17 2018

Part Op 100 - 1-Assemble as per DWG sheet 1. ***Note 32446 22-16 crimp connectors supplied loose as per note 1***
Descriptions: 130 - Bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
32446	Crimp Terminal	2120 Ea (2 ea)	90-Start up Operation	5047075
92373A143	Spring Pin	10 Ea (1 ea)	90-Start up Operation	5060727
C3-8-2-1	Solenoid	10 Ea (1 ea)	90-Start up Operation	5114113
C3-8-2-2	Solenoid Pin Spacer	120 Ea (1 ea)	90-Start up Operation	5075400
C3-8-3-1	Spacer	10 Ea (1 ea)	90-Start up Operation	5104175

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	32446	20	578	0
		10	84	0
		10	25	0
		10	0	0
		10	62	0



Container No: S137893



Part: C3-8-2

Job No: 184032

Serial No/Batch: S137893

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 12/17/18

ions

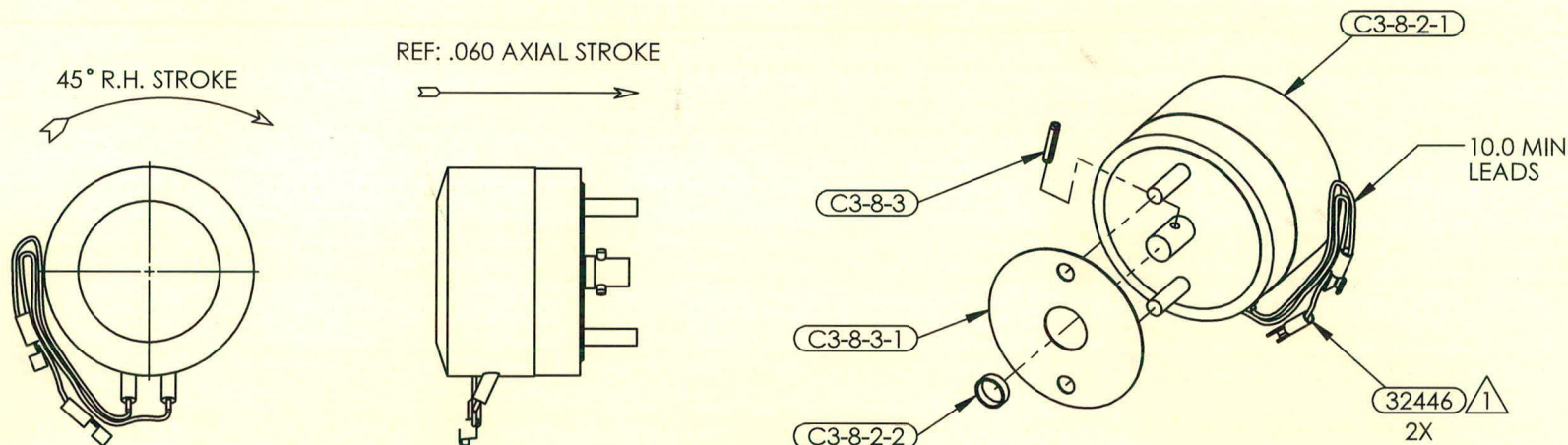
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Plex 10/2/18 6:51 AM Dart.lajeunesse.marie

300
15
100

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SPACER C3-8-31.	10/10/2012	RJC	DW
1A	14-0111	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED ENGRAVE NOTE. ADDED NOTE $\triangle$.	8/7/2014	DJN	RW
2	14-0195	C3-8-2-1 CH'D DIM WAS LIMITS $\varnothing.0933-.0937$ IS LIMITS $\varnothing.094-.097$. ADDED "(CLOCKWISE)" TO NOTE $\triangle$. CH'D NOTE 4 WAS PLACE BUSHING AND PIN IN PLACE AS SHOWN AFTER DRILLING IS INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING. ADDED ENGRAVE BATCH NUMBER NOTE. C3-8-3-1 CH'D DIM WAS $\varnothing2.285$ IS $\varnothing1.95$. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	10/23/2014	DPD	JAG
3	15-0243	UPDATED TO NEW DRAFTING STANDARDS. C3-8-3-2 DELETED; REPLACED WITH 32446 .	8/25/2015	DPD	JAG



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 184032 MWS
1810-02

NOTE:

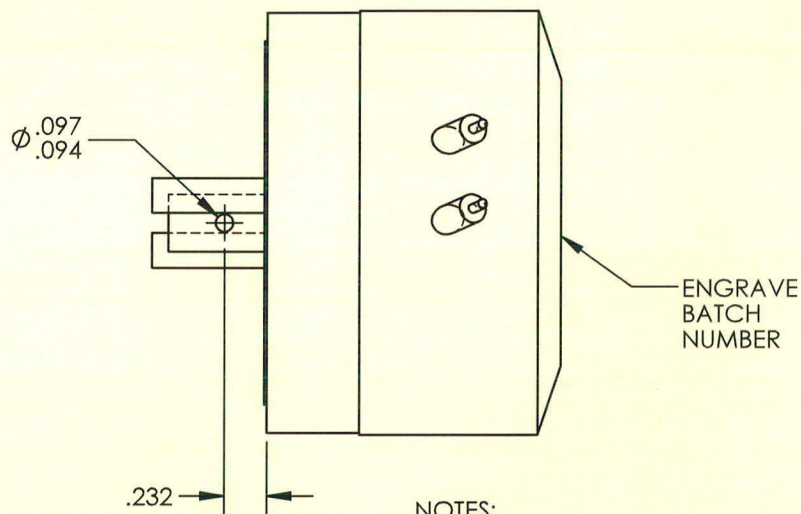
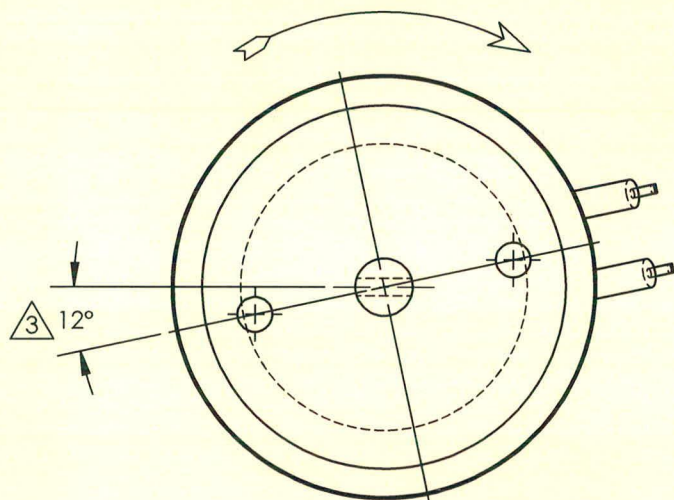
$\triangle$ CONNECTIONS SUPPLIED LOOSE.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	C3-8-2-1	1	SOLENOID		TESTCO #152951-001	1,2
			C3-8-2-2	1	SOLENOID PIN SPACER	303 S.S.		3
		B/O	C3-8-3	1	SPRING PIN	18-8 S.S.	$\varnothing3/32$ X 1/2 (MCMASTER-CARR #92373A143)	1
		B/O	C3-8-3-1	1	SPACER	PETG		4
		B/O	32446	2	22-16 AWG KNIFE CONNECTOR		(ALLIED ELECTRONICS 32446)	1

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: CANAM APPROVED: D Well HEAT TREAT FINISH SPEC USED ON MODEL	
SCALE 1:2	DATE 12/19/2001
SHEET 1 OF 4	

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
2	14-0195	C3-8-2-1 CH'D DIM WAS LIMITS Ø.0933-.0937 IS LIMITS Ø.094-.097. ADDED "(CLOCKWISE)" TO NOTE 3. CH'D NOTE 4 WAS PLACE BUSHING AND PIN IN PLACE AS SHOWN AFTER DRILLING IS INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING. ADDED ENGRAVE BATCH NUMBER NOTE.	10/23/2014	DPD	JAG	



NOTES:

1. USE C3-8-2-F1 FIXTURE FOR DRILLING THE PIN HOLE.
2. REMOVE COIL SPRING BEFORE DRILLING HOLE.
3. TURN SHAFT AS SHOWN IN FIXTURE BEFORE DRILLING (CLOCKWISE).
4. INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING.

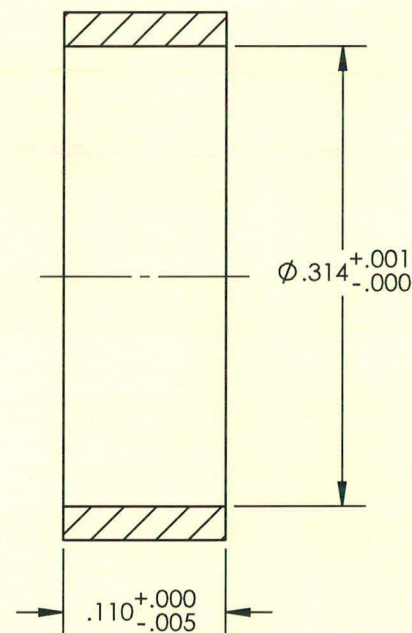
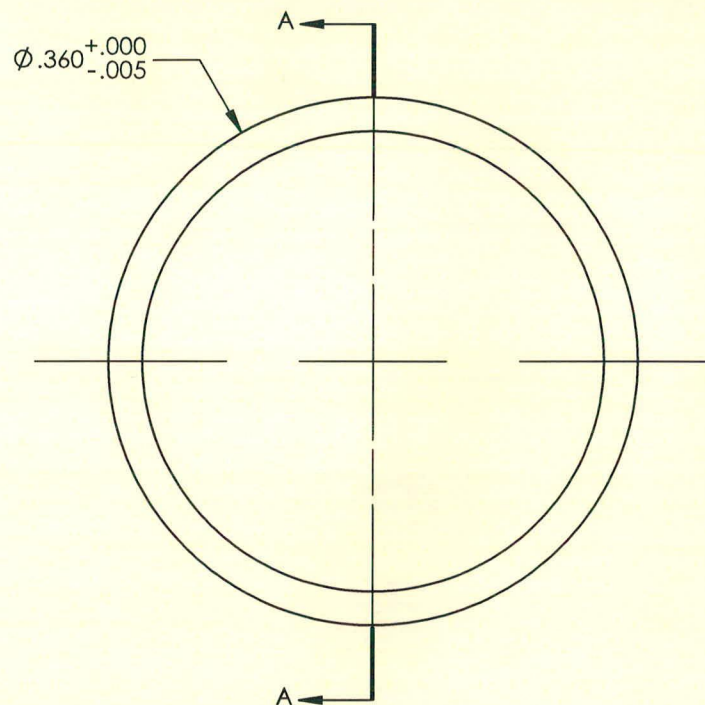
C3-8-2-1

SOLENOID WITH PINNED HOLE

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CANAM APPROVED: D Weil HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:1	DATE 12/19/2001
SHEET 2 OF 4	

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				



SECTION A-A

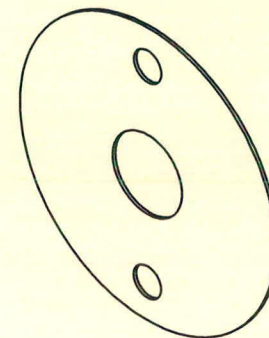
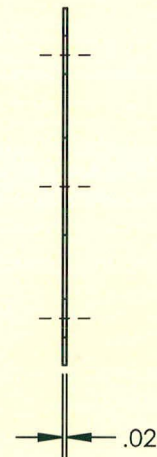
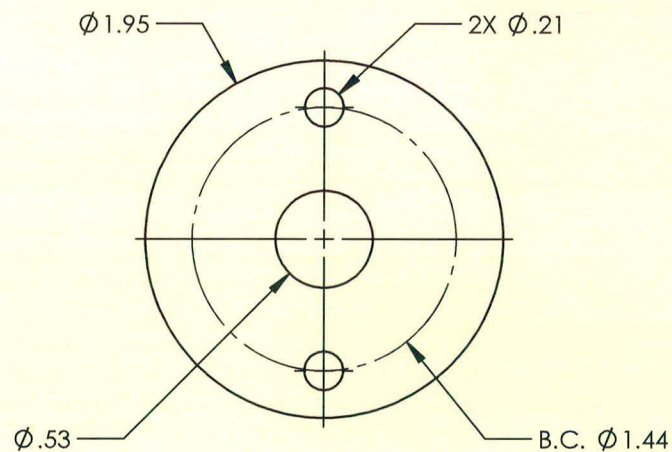
C3-8-2-2

SPACER

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L 303 S.S.	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT
.XX ± .01 ANGLES ± 5°	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 8:1	DATE 10/31/2001 SHEET 3 OF 4

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SPACER C-3-8-3-1	10/10/2012	RJC	DW
2	14-0195	C3-8-3-1 CH'D DIM WAS Ø2.285 IS Ø1.95.	10/23/2014	DPD	JAG



C3-8-3-1

SPACER

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L PETG	DRAWN BY:
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010	HEAT
.XX ± .03	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:1	DATE
SHEET 4 OF 4	

